

Work Order ID 78350

Thursday, January 05, 2012 3:22:03 PM

78350

Page 1

Item ID: D4005-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Floor Gutter

Stop ***NS2***

Start Date: 1/6/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: mf

Date: 12-01-06 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4005

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4005-13)

Dwg Rev: A

Prog Rev: A

2024.000

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-6

B12-2-6

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

Bend D4005-13 as per Dwg

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

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Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
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Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

141

Weld per dwg A/R Aluminum rod Batch: 119785 0.00***141***

Large Fab

Memo

0.00

Large Fab

1- Weld D4003-13 tube to angle as per dwg D4005
2- grind flush as per dwg6/12.00.148x Ø

142

QC9- Inspect visual per QSI004- Fusion Welds 0.00

142

QC

Memo

0.00

Quality Control

8 Ø BE12/02/14

143

QC5- Inspect part completeness to step on W/O 0.00

143

QC

Memo

0.00

Quality Control

S n l r l yCS

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 114

0.00

190

Packaging

Memo

0.00

Packaging

12/15 82

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/02/1612/02/16

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Picklist Print

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Work Order ID: 78350

Parent Item: D4005-041

Parent Item Name: Fwd Floor Gutter

Start Date: 1/6/2012

Required Date: 1/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.21 new issue Prelim EC verified by:DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	26.3184	0.42	1.7684211			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		26.318421							
				117684		26.318421							
D4003-13 Fwd Fuel Gutter Line		Manufactured	No			141	Each	0.0000	1	4			

1812-2-6

120196

8
CPL 12-02-14

378374 → 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

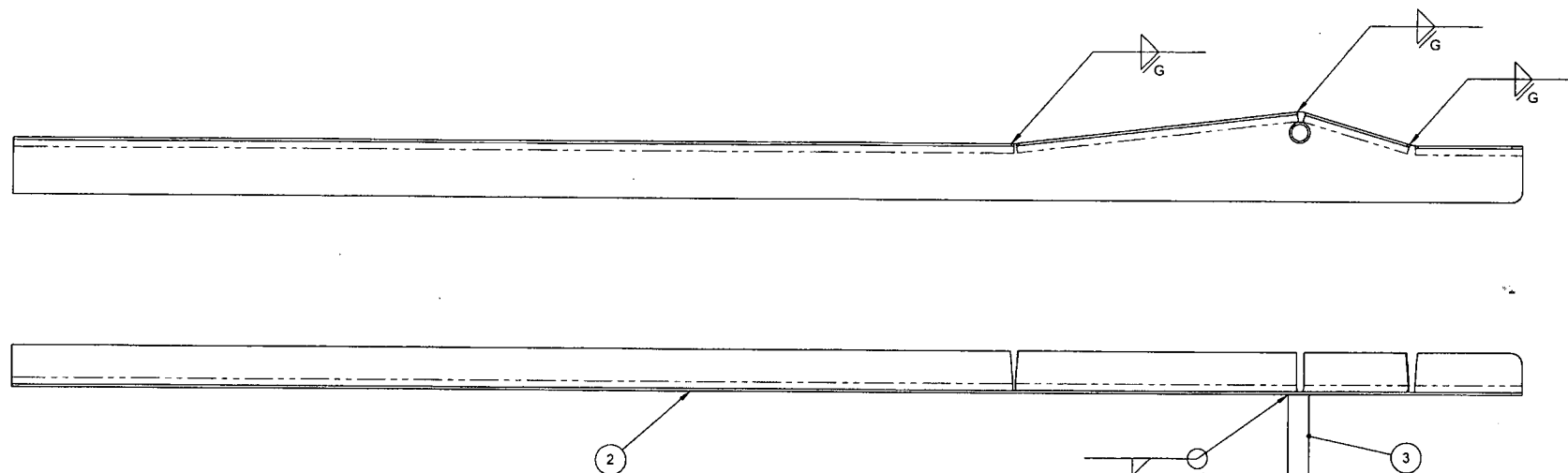
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4005-041	FORWARD FLOOR GUTTER	JCA-M47-2-22
2	1	D4005-13	ANGLE	
3	1	D4003-13	TUBE	



D4005-041 FORWARD FLOOR GUTTER

RELEASED
R 2010-05-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAT QSI 005 4.2
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DAT QSI 005 4.3
- 3) TOLERANCES: PER DAT QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.22 lbs
- 8) WELD PER DART QSI 004

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.02.05			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4005** REV. A
SHEET 1 OF 15
TITLE **RESTRAINT** SCALE NTS

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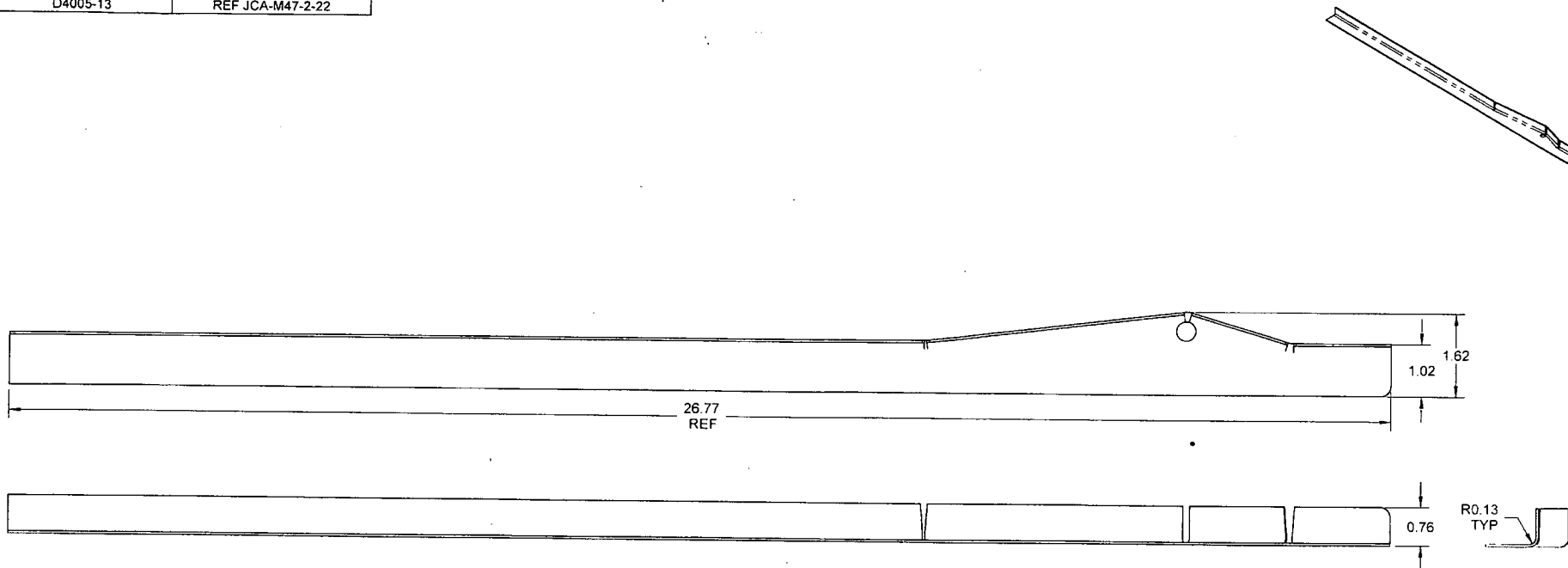
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-13	REF JCA-M47-2-22









D4005-13 ANGLE

RELEASED
R 2010-05-05
ND

#78350

NOTES:

- 1) MATERIAL: MADE FROM D4005-13F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4005	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		RESTRAINT	NTS
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Dart Aerospace Ltd

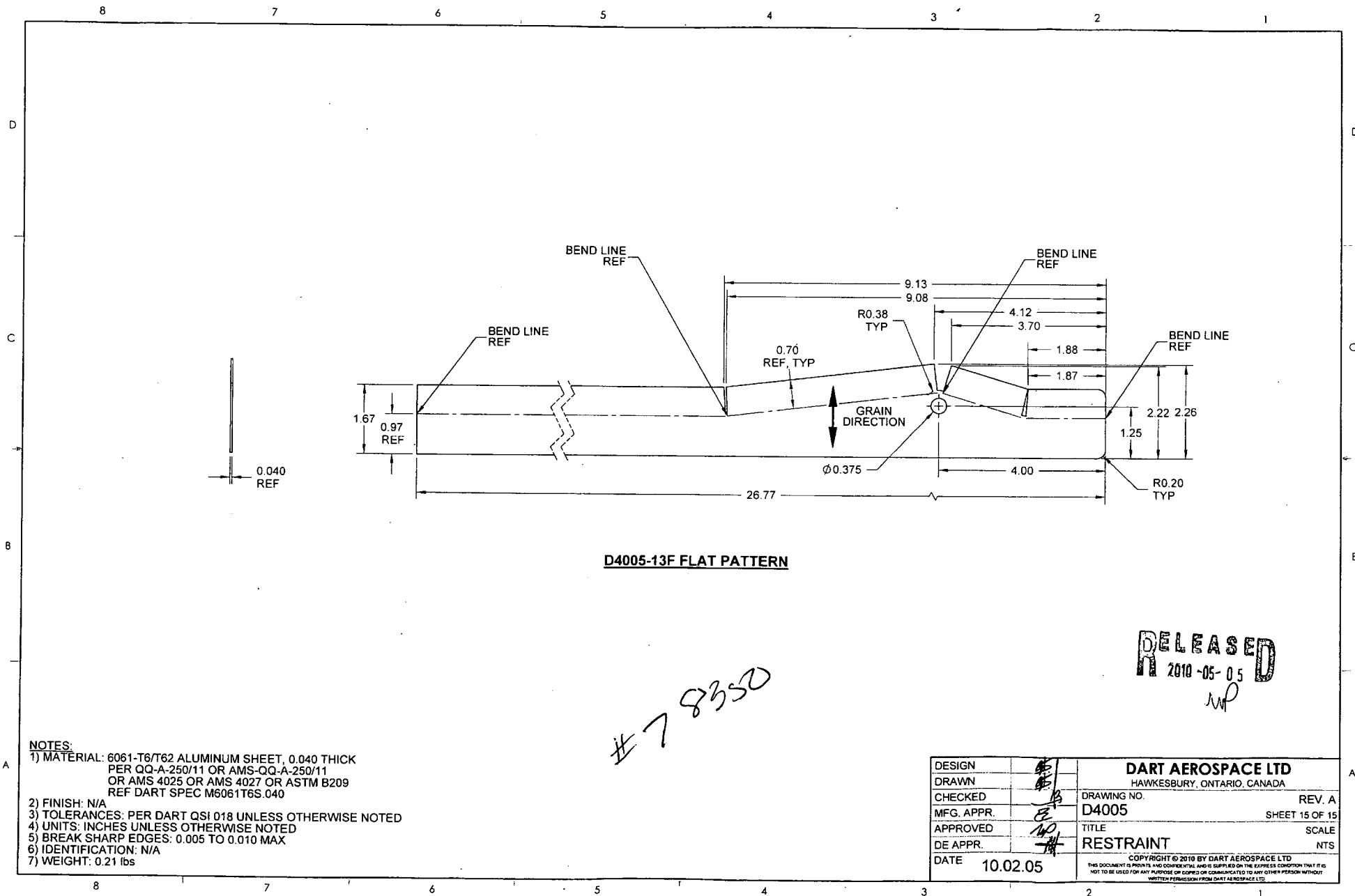
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